Item ID:	D2237		Accept	*N9000401 00*	Setup	Start	*NS1*
Revision ID:						Stop	*NS2*
Item Name:	Striker Plate						

Start Date:	2/14/13	Start Qty: 40.00	*40*	Cust Item ID:		
Required Date: 2/21/13		Req'd Qty: 40.00	*40*	Customer:		
Reference:					Run	Start	*NR1*

Approvals: Process Plan: _MLJ_ Date: _13-02-15_ Tooling: _____ Date: _____   Stop   *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2237	Rev D1								
100 *100* Waterjet FLOW CNC Waterjet 304·032	FLOW WATER JET	0.00				40	0		JmB-6-18
	Memo 1-Cut as per Dwg D Dwg Rev: _01_ Prog Rev: _01_ 2-Deburr if necessary	0.00							
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00				40	0		Jm13-6-18
	Memo	0.00							
120 *120* QC Quality Control	QC8- Inspect parts - second check	0.00				40 Coun			
	Memo	0.00 13-6 19							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**			
Part No. _____	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Work Order Update ☐		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Item ID:	D2237			Accept	*N9000401 00*	Setup	Start	*NS1*

Revision ID:

Item Name: Striker Plate

Stop *NS2*

Start Date:	2/14/13	Start Qty:	40.00	*40*		Cust Item ID:	
Required Date:	2/21/13	Req'd Qty:	40.00	*40*		Customer:	

Reference:

Run Start *NR1*

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo 1-Form as per drawing	0.00 0.00				40			*SB* 13/06/19
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	*DAS 27* 13-6 19			40 Count	1		
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: STOO7 Memo	0.00 0.00				40x		M.W. 13-06-19	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION
- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS
- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear
- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled

- ☐ Other
- _____
- _____
- _____

Item ID:	D2237			Accept	*N9000401 00*	Setup	Start	*NS1*
Revision ID:							Stop	*NS2*
Item Name:	Striker Plate							

| Start Date: | 2/14/13 | Start Qty: | 40.00 | *40* | | Cust Item ID: | | |
| Required Date: | 2/21/13 | Req'd Qty: | 40.00 | *40* | | Customer: | | |

Reference:

					Run	Start	*NR1*
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____		Stop	*NR2*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00						MLJ 13-06-20	
160									
QC	Memo	0.00						MLJ 13-06-19	
Quality Control									

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No

QA Closed: Date:

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Work Order ID:	96996									
Parent Item:	D2237						**Start Date:** 2/14/13		**Required Date:** 2/21/13	
Parent Item Name:	Striker Plate						**Start Qty:** 40.00		**Required Qty:** 40.00	

Comments: IPP C02.05.11Clarify IPPNG
IPP D 06.05.25   Waterjet   EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	222.2600	0.01	0.421052 0.5		Jm 13-6-18	

Location	Loc Qty	Loc Code
MAT020	222.26	
118271	10.76	
120866	55.6	
121889	155.9	121889

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____   Date: _____

QA Closed: _____   Date: _____

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear		General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other .
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		_____
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		_____
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		_____
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

DART AEROSPACE LTD				Work Order:	96996	
Description: Striker Plate				Part Number:	D2237	
Inspection Dwg: D2237 Rev: D1					Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010	0.298"	—		V	Jkmo1
0.250	+/-0.010	0.250"	—		V	
1.550	+/-0.010	1.549"	—		V	
1.800	+/-0.010	1.799"	—		V	
0.750	+/-0.010	0.748"	—		V	
$\varnothing$0.128	+0.005/-0.001	0.130"	—		V	
0.034	+/-0.010	0.028"	—		V	

Measured by:	Jm	Audited by:	27	Prototype Approval:	N/A
Date:	13-6-18	Date:	13-6 19	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	07.05.31	New Issue		KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2237	SHEET 1 OF 1
DATE		TITLE	SCALE
94:10:25		STRIKER PLATE	2:1

D1		04.06.15	UPDATE DIMENSION

RELEASED
97/12/17 DS

0.180 +0.010 −0.030

0.135

△ D1

R0.032

BEND DETAIL

Ø0.128 (2)

1.800

0.750

0.300

0.000

0.000

0.250

1.550
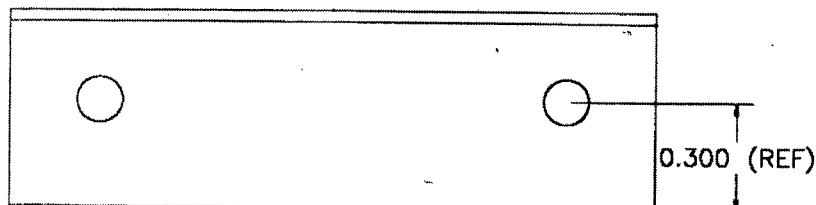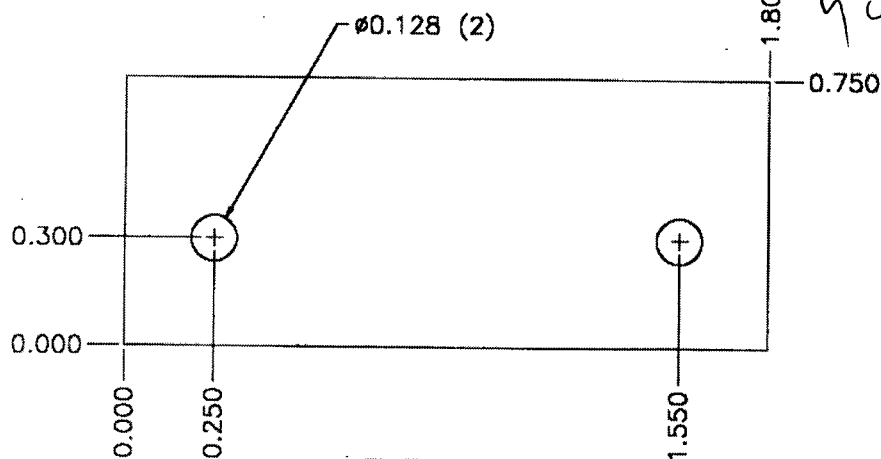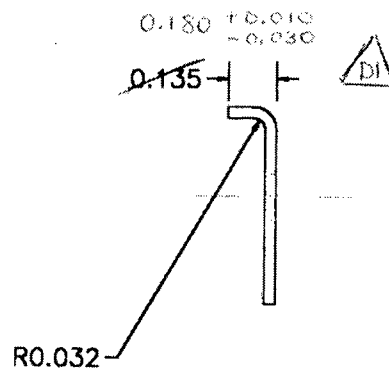
FLAT LAYOUT

MATERIAL: 304/316 SS, 0.034 THICK